

Date: Monday, 18/08/2008 4:03:54 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE GUIDE
Job Number	: 41347		
Estimate Number	: 10484		
P.O. Number	:	Part Number	: D34401
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: D3440 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 18/08/2008 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 40047	Material	:
Written By	:	Due Date	: 15/09/2008
Checked & Approved By	: <u>JLD 08.8.18</u>	Qty:	20 Um: Each
Comment	: Est. A 05.08.10 New issue KJ/JLM Est B 08.06.24 Re-formated EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X04000	6061T6 Bar 2.00 x 4.00
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7.7700 f(s)

Comment: Qty.: 0.3885 f(s)/Unit Total: 3.1080 f(s)

6061T6 Bar 2.0" x 4.0"

Batch: M18169

M.A

08/08/22

(20)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks 4.200" long

M.A

08/08/22

(20)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine as per Folio FA 551 and Dwg D3440

JLD 08/09/14 JLD 08/09/17

(PTO)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLD 08/09/17

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JLD 08/09/17

(20)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.A 08/09/17

(20X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3440-1 PAR #: N/A Fault Category: Prod/Manufact Yes No NCR: Yes No DQA: D Date: 08/09/22
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 08/09/22

NCR: <u>41347</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/09/15</u>	<u>3.0</u>	<u>the center drill, drill at the wrong place. and make a mark.</u> <u>R.C. operator error</u>	<u>[Signature]</u> <u>Q5142</u>	<u>Scrap and destroy</u> <u>and Replne B2 18/69</u> <u>Qty ②</u>	<u>[Signature]</u> <u>08/09/15</u>	<u>S.F</u> <u>08/09/16</u> <u>...</u>	<u>[Signature]</u> <u>08/09/16</u>	<u>[Signature]</u> <u>08/09/16</u>
						<u>IL</u>		

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:03:54 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE GUIDE

Job Number: 41347

Part Number: D34401

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M102316



Comment: POWDER COATING

Mask stem per note 3 of dwg D3440

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

1:45pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:15pm

911

08-09-18

20X

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/9/18

20X

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 93

8/9/18

SD

20X

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/19

Job Completion



MF 08-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41347
Description: Tube Guide		Part Number: D3440-1
Inspection Dwg: D3440	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.38	+/-0.030	0.38	✓			
R1.10	+/-0.030	1.10	✓			
Ø1.780	+0.012/-0.001	1.780	✓			
R0.125	+/-0.010	0.125	✓			
0.38	+/-0.030	0.373	✓			
59°	+/-0.5°	59°	✓			
R0.13	+/-0.030	0.130	✓			
1.00	+/-0.030	1.00	✓			
R0.03	+/-0.030	0.030				
2.241	+/-0.010	2.248	✓			
1.05	+/-0.030	1.05				
0.523	+/-0.010	0.523	✓			
1.00	+/-0.030	0.998	✓			
0.500	+/-0.010	0.500	✓			
Ø0.859	+0.000/-0.005	0.858	✓			
1.00	+/-0.030	0.997	✓			
Ø0.257	+0.006/-0.001	0.260	✓			
Ø0.507 x 100°	+/-0.010 x +/-0.5°	0.515 x 100°	✓			
2.940	+/-0.010	2.940	✓			
3.75	+/-0.030	3.750	✓			

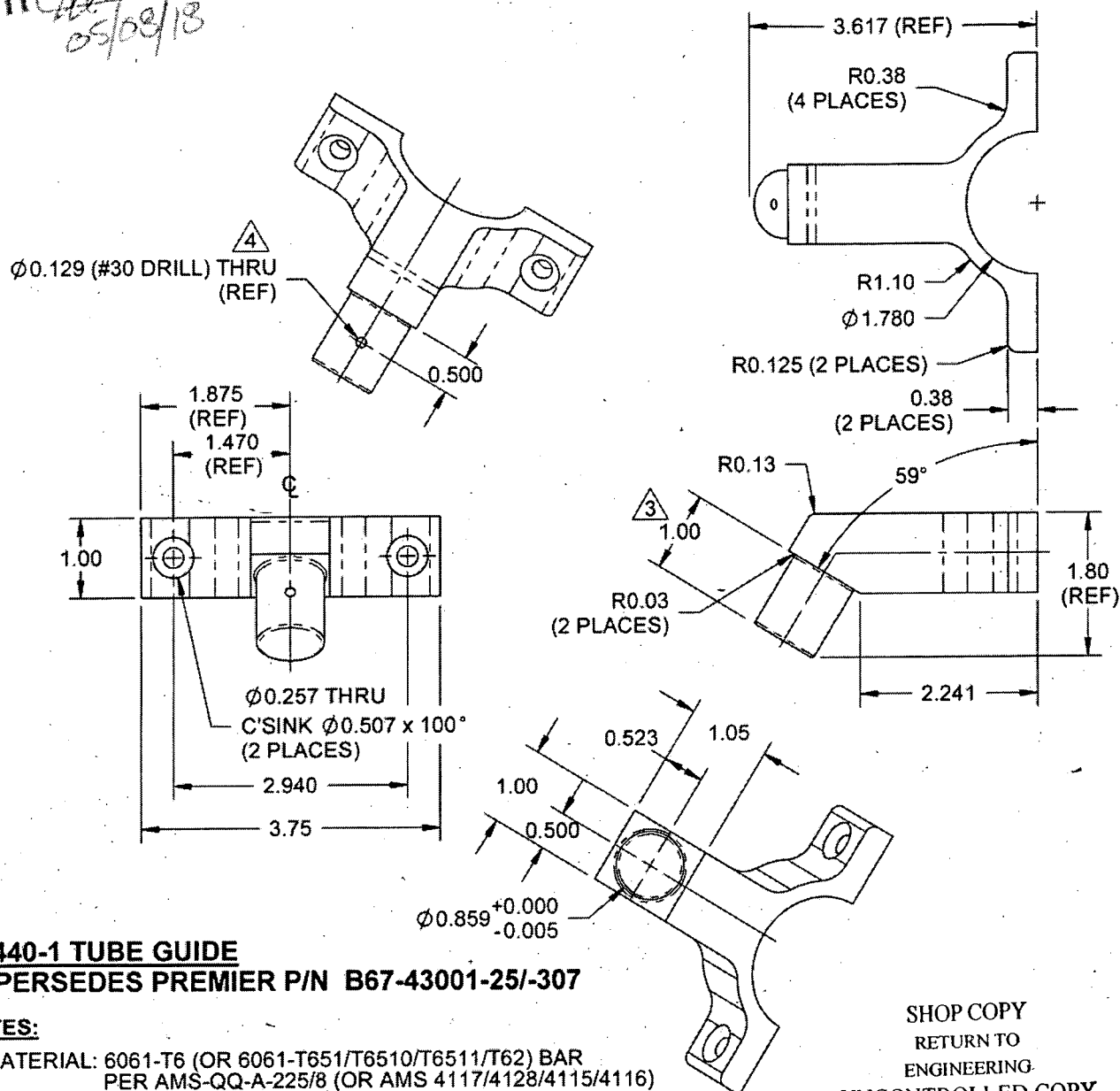
Measured by: DJP	Audited by: S.P.	Prototype Approval:	N/A
Date: 08/09/15	Date: 08/09/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.23	New Issue	KJ/DD	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3440	REV. A SHEET 1 OF 7
DATE 05.06.02	TITLE BLADE FOLD KIT PARTS		SCALE 1:2
A	05.06.02	NEW ISSUE	

RELEASED
05/08/18



D3440-1 TUBE GUIDE
SUPERSEDES PREMIER P/N B67-43001-25/-307

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ-A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) MASK BEFORE PAINTING.
- 4) DRILL HOLE AT ASSEMBLY.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

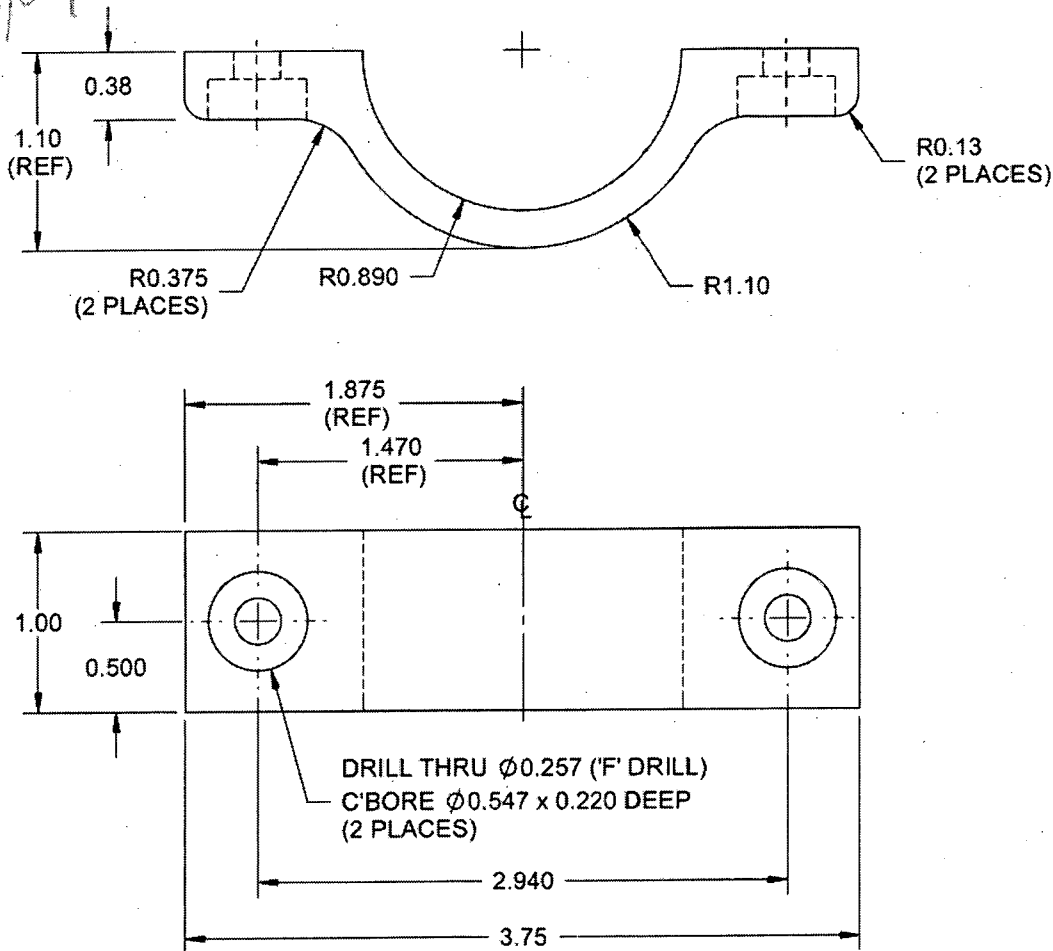
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DATE 05.06.02	TITLE BLADE FOLD KIT PARTS		SCALE 1:1

**D3440-3 CLAMP****SUPERSEDES PREMIER P/N B67-43001-309****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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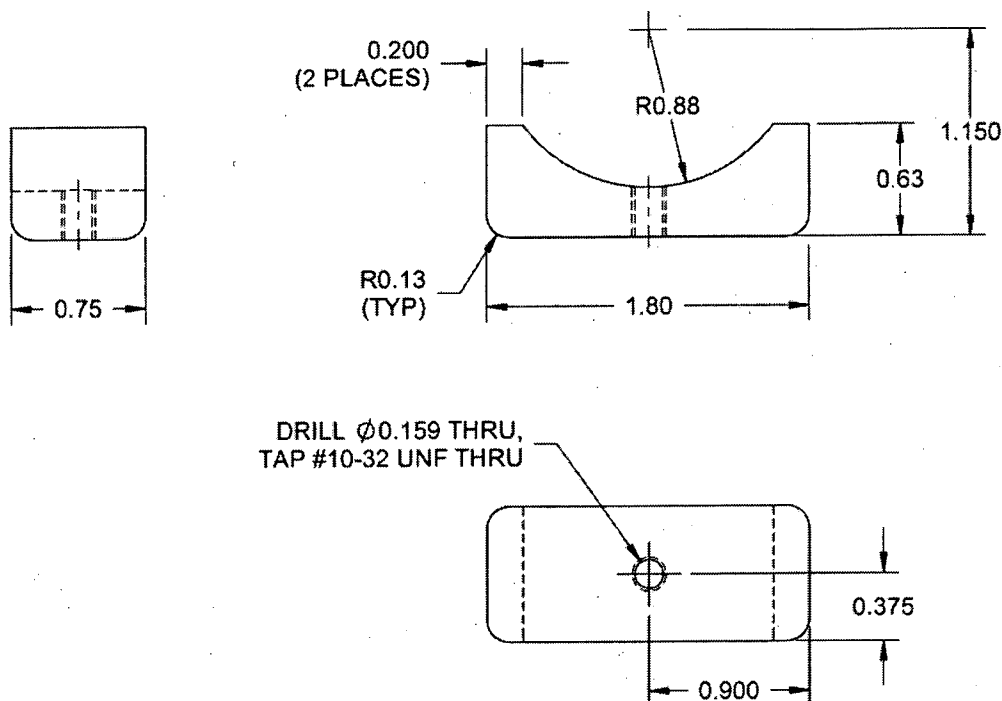
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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05/08/18



D3440-5 CONTOURED DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-217

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QT/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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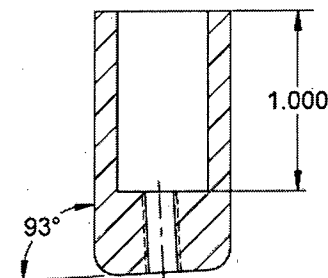
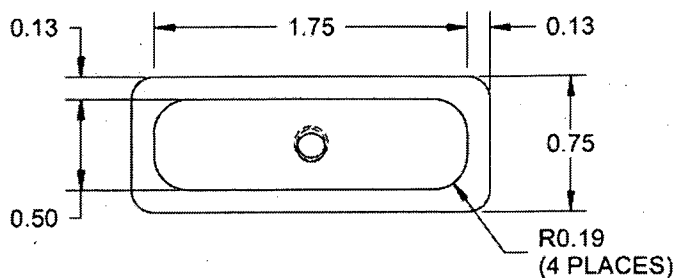
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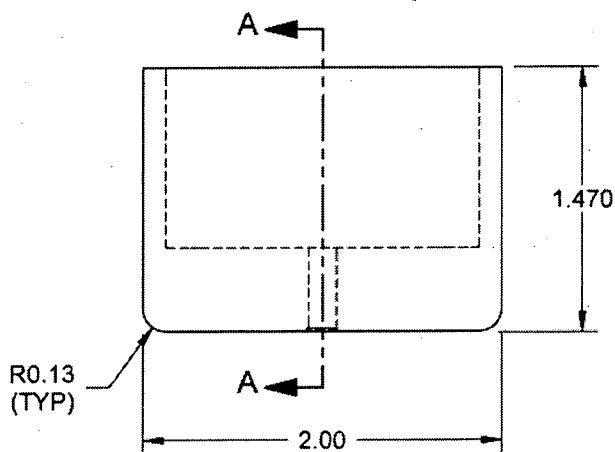
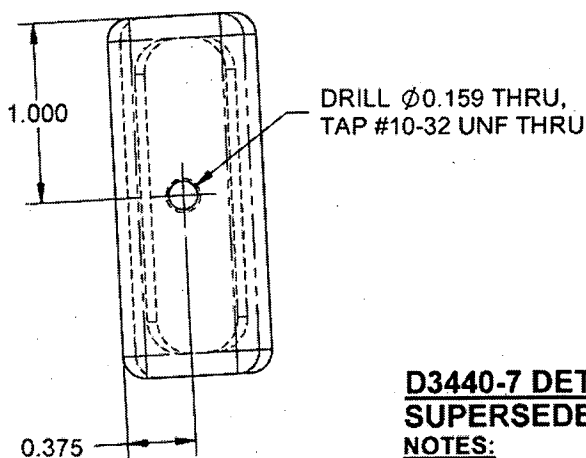
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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SECTION A-A



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D3440-7 DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-221

NOTES:

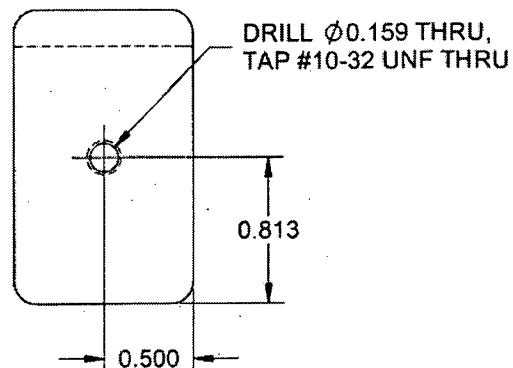
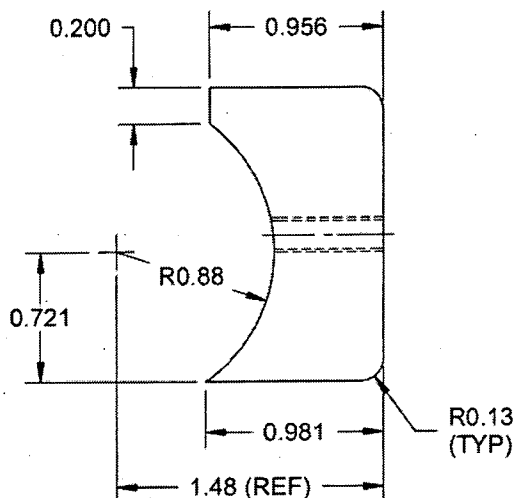
- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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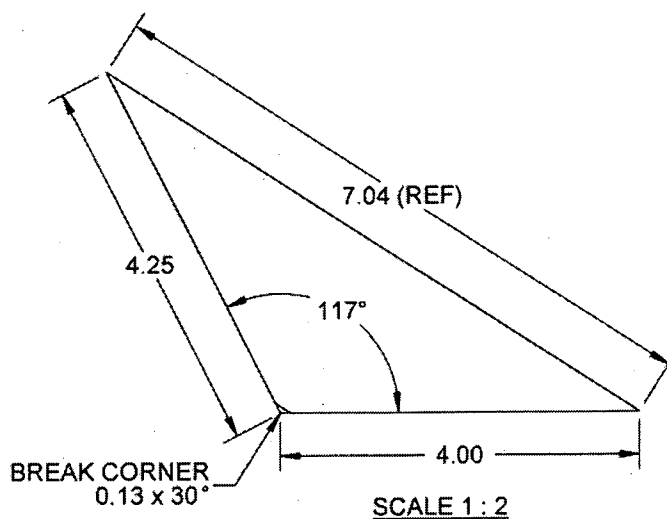
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1



D3440-9 TUBE DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-241

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)

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SCALE 1:2

D3440-11 GUSSET

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.250)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

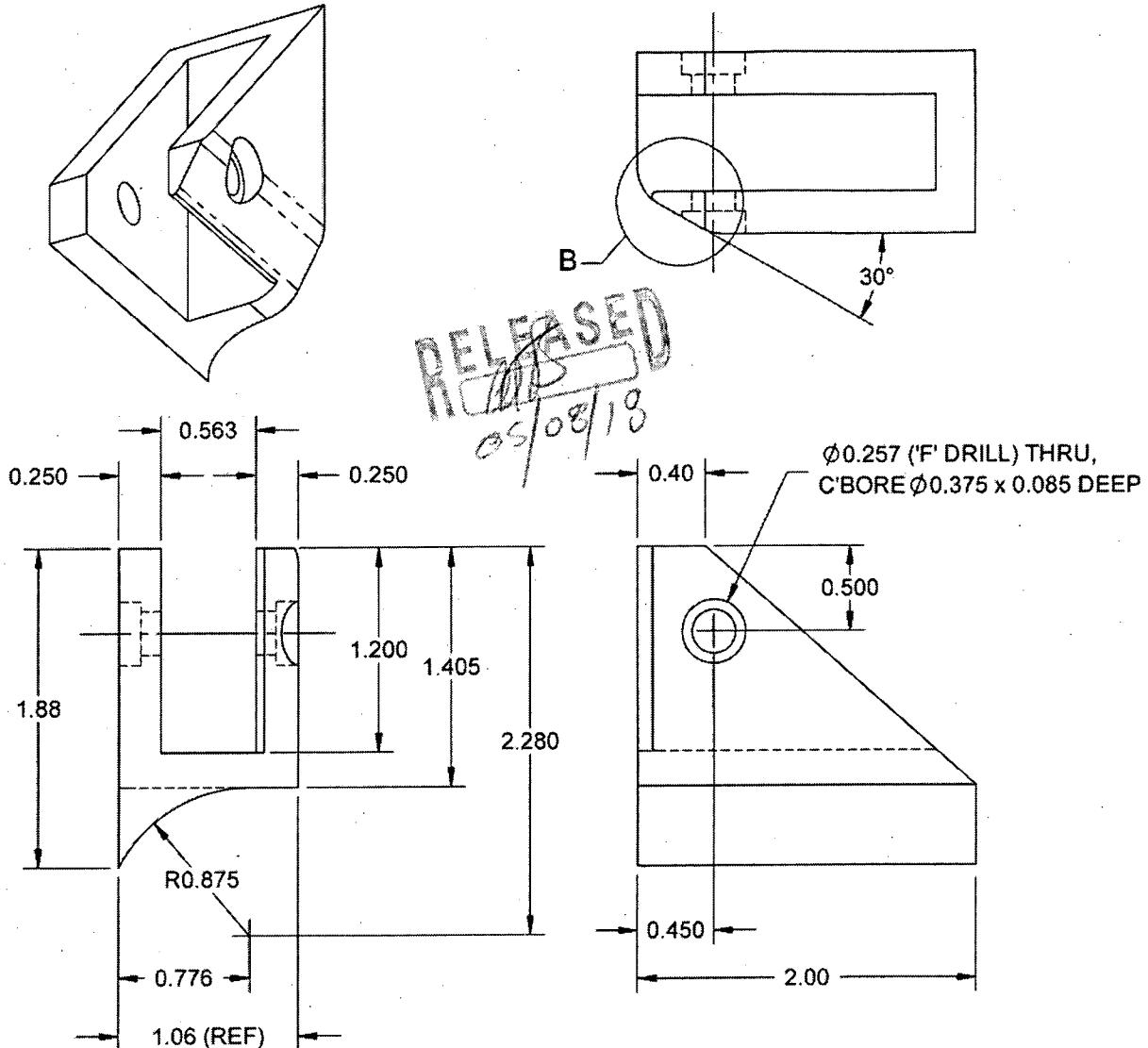
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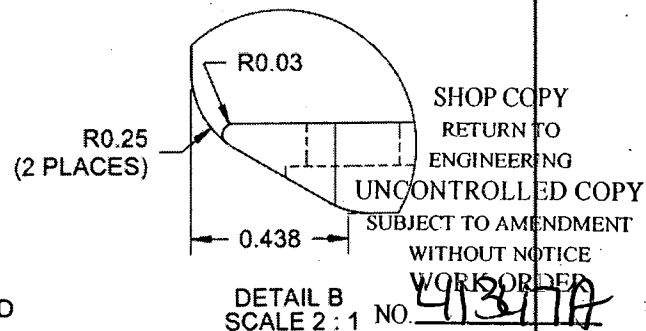
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1



D3440-13 BRACKET
SUPERSEDES PREMIER P/N B67-43001-273

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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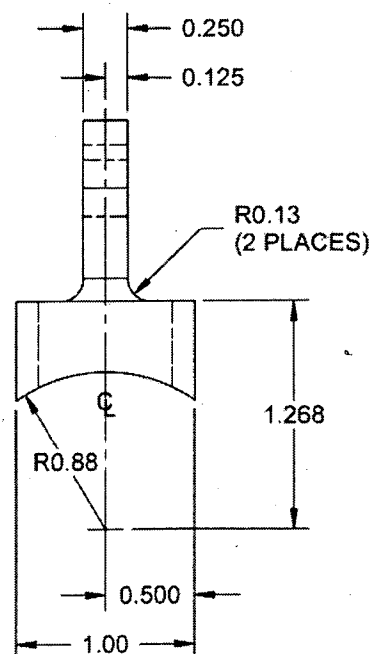
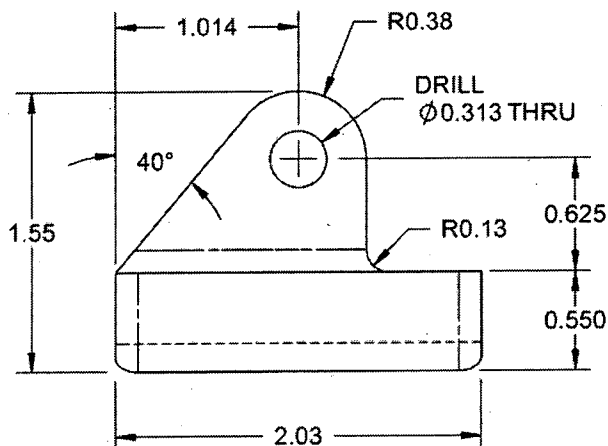
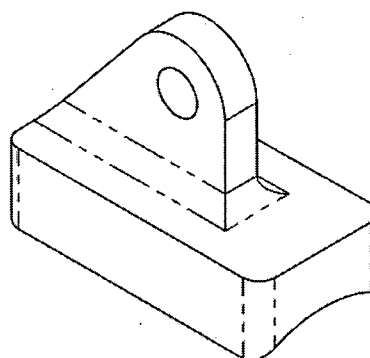
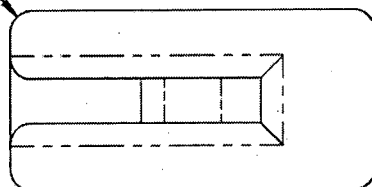
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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05/08/18

R0.13
(4 PLACES)



**D3440-15 CONTOURED MALE EYE
SUPERSEDES PREMIER P/N B67-43001-215**

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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